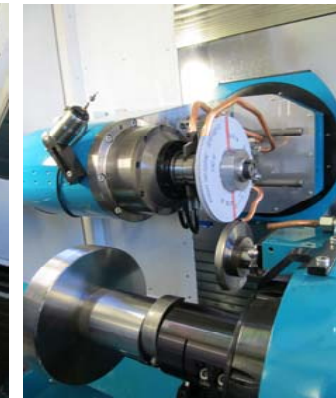


Special ThreadingRoll Ø200 L40 Z78 P1.513

A21-010

In this particular threading roll main thread, entry and exit have been ground with the same wheel. For each of the parts the wheel has been reshaped with its according profile. The profile being very thin, it can be recommended to use CBN for roughing and eventually finishing. In case of Corundum, also roughing and finishing wheels should be used for cutting into half the grinding time.



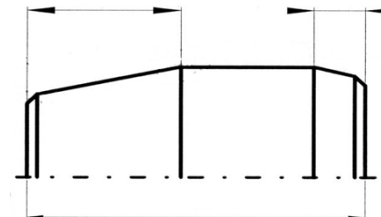
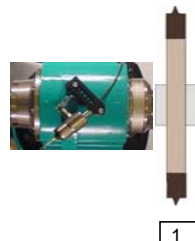
1. Cycletime for Production

Workpiece: Ø200.4, L40, Helix 118.055 Material HSS														
Operations														
Dress	36	2000	36	2000	36	2000	36	2000	36	2000	36	2000	36	2000
Feed [mm/Min]	0.1/0.01	1.0/0.01	0.8/0.01	0.25/0.01	0.3/0.01	0.03/0.01	0.5/0.01	0.35/0.01	0.2/0.01	0.03/0.01	0.5/0.01	0.15/0.01	0.2/0.01	0.03/0.01
Increments [tot./part.]	12	45	12	45	12	45	12	45	12	45	12	45	12	45
Cutting speed [m/s]														
Used wheels	1	1	1	1	1	1	1	1	1	1	1	1	1	1
Grinding time [s]	200	47154	1600	11788	600	1415	1000	16504	400	1415	1000	7073	400	1415
Total cycle time	25 h 32 min 43 s													

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø200 C220
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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR Coolant: Synthetic Oil, pressure 10 bar
Control: Fanuc 31i Software: Quinto 5
Accessories: Dresser

Responsible engineer: OP, 25.5.13

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